

ABSTRACT OF THE DISCLOSURE

A control structure for the active damping of low-frequency oscillations in numerically-controlled machine tools. The control structure includes an rpm regulator having a proportional component and an integral component. The control structure further includes an active damping element that forms a low-frequency correction signal, which is phase-shifted with respect to an interfering low-frequency oscillation and free of d.c. components, and a summing point that is upstream or downstream of the integral component and receives the low-frequency correction signal.